

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028451**Date Inspected:** 18-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**OBG 12W**

This QA observed the following welders working in OBG 12W at various locations:

Authorized welder Jin Quan Huang #9340:

Welder Jin Quan Huang was observed welding and grinding on weld 12W W2.1-A1. The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1001-R and preheating the weld to the over 200 degrees Fahrenheit prior to weld. The areas welded were areas noted for visual surface porosity after the weld cap was ground smooth in preparations for Ultrasonic Testing Shear Wave (UTSW). Welder was observed welding as per Welding Procedure Specification's (WPS) noted above at Y location 3000 and 10000.

Authorized welder Guo Wu Chen #1556:

Welder Guo Wu Chen was observed welding and grinding on weld 12W W2.1-A1. The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1001-R and preheating the weld to the over 200 degrees Fahrenheit prior to weld. The areas welded were areas noted for visual surface porosity after the weld cap was ground smooth in preparations for Ultrasonic Testing Shear Wave (UTSW). Welder was observed welding as per Welding Procedure Specification's (WPS) noted above at Y location 13000.

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Authorized welder Chris Bruce #8901:

Welder Chris Bruce was observed welding on weld 12W PP113 W2.1-BW2 (3G, CJP). The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030; preheating to the specified temperature prior to welding. Welding parameters observed were as per Welding Procedure Specification's (WPS) noted above and appears to be in order.

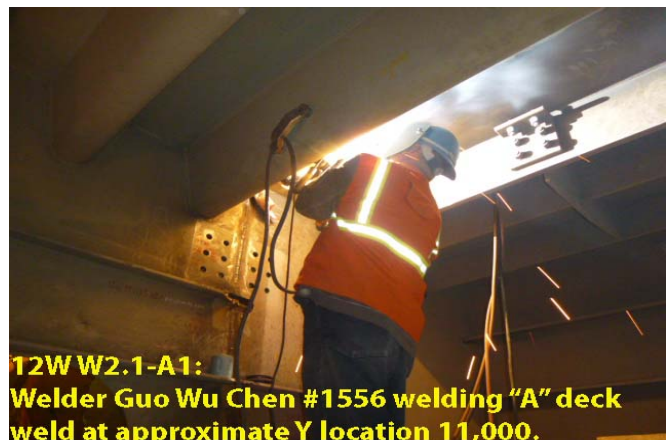
Welder Chris Bruce was also observed welding on weld 12W W2.1-A1. The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1010R; preheating to the specified temperature prior to welding. Welding parameters observed were as per Welding Procedure Specification's (WPS) noted above and appears to be in order.

This QA randomly observed QC Inspectors Barry Drake checking the Welding Procedure Specification or WPS compliance of welders throughout the day. Also noted this day was QC Inspector Andrew Keech performing Magnetic Particle Testing (MPT) on weld 12W W2.1-A1 at Y location 0 onwards. Magnetic Particle Testing (MPT) is not complete at this point and will continue tomorrow or at a later date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



**12W W2.1-A1:  
Welder Jin Quan Huang #9340 welding multiple  
Visual Testing (VT) rejects at Y 10,000 approx..**



**12W W2.1-A1:  
Welder Guo Wu Chen #1556 welding "A" deck  
weld at approximate Y location 11,000.**



**12W W2.1-A1:  
Welder Chris Bruce #8901 preheating the weld  
at Y 7000 prior to welding.**



**12W PP113 W2.1-BW2:  
Welder Chris Bruce #8901 preheating the panel  
point web splice prior to welding.**

### Summary of Conversations:

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Conversations relevant to work performed on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Belford,Fritz	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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